

Date: Tuesday, 18/03/2008 7:16:07 AM
User: Linda Lacelle

Slip 20/03

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350/212/130 BASKET LID
Job Number : 38070	
Estimate Number : 10193	
P.O. Number :	Part Number : D2512
This Issue : 18/03/2008 S.O. No. :	Drawing Number : D2512 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : D2
Previous Run : 37723A	Material :
Written By : <i>[Signature]</i>	Due Date : 20/03/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)
Pick:
3/4"x3/4" 304/316 SS tube .063" wall
Batch: *M107315* ✓

Sl 08/03/18

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3166-3 Basket Hoop *B37612* ✓

Pl 08.03.19

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2506 Label Plate *B35585* ✓

Pl 08.03.19

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2327-1 Bushing *B36920* ✓

Pl 08.03.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/03/2008 7:16:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 38070

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

335684 ✓

PL08.03.19

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

336481 ✓

PL08.03.19

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M107368 ✓

PL08.03.19

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

LD 08/03/18

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PL08.03.19

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LD 08.03.19 ©

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/03/2008 7:16:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 38070

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

10 08/03/20 (1)

11.0

POWDER COATING

POWDER COATING



M107005



(72)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 08/03/20

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M107385

Spray Paint: m107230

Fd 08/03/20 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/03/20 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 08/03/20 (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/20 (1)

Job Completion



08/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

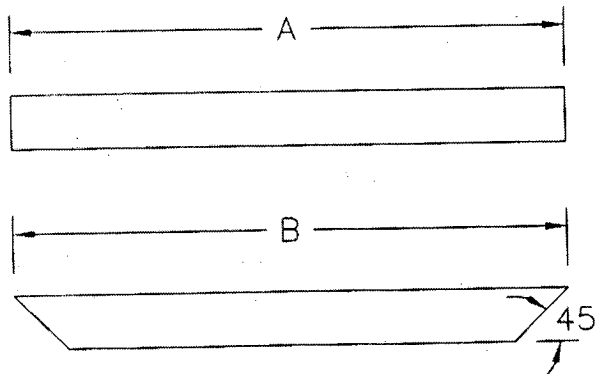


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	<i>[Signature]</i> 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	<i>[Signature]</i> 04.01.20	TUBE WELD ONE SIDE (RED)	

RELEASED
01.04.27 *[Signature]*

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



UNDER REVIEW
08.02.05 *[Signature]*
TUBING TO BE
CHANGED TO 0.065
WALL

[Signature]
38070

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

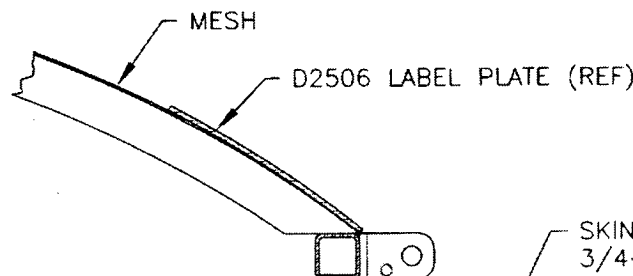
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

QA COPY ISSUED

DESIGN	BW	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.04.19	DRAWING NO.	D2512	REV. D
		TITLE	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE	1:20	

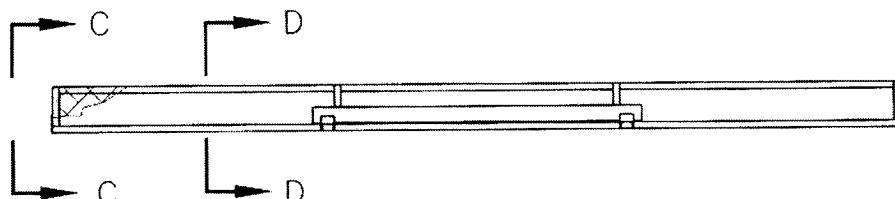
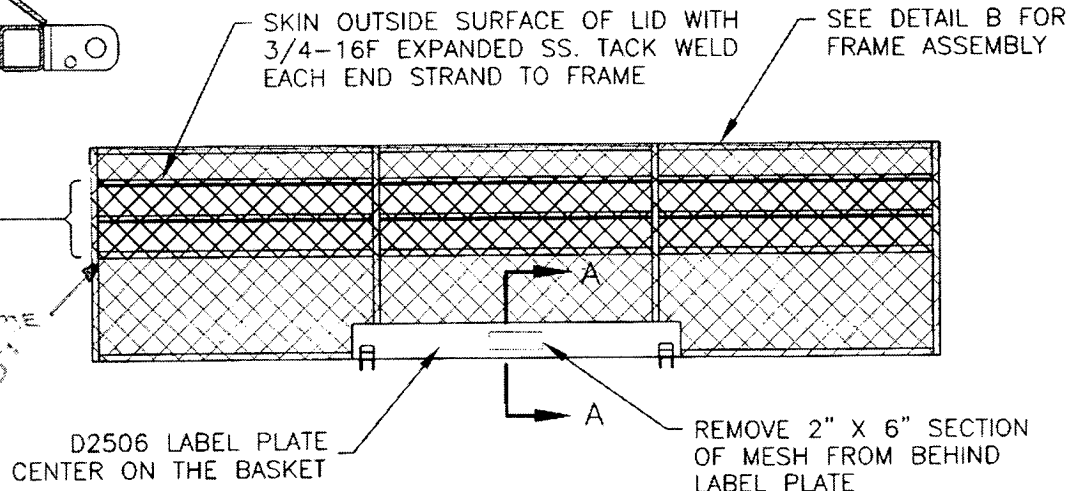
UNDER REVIEW
08.01.06 PM
TUBING TO BE
CHANGED TO 0.015
WALL



SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY

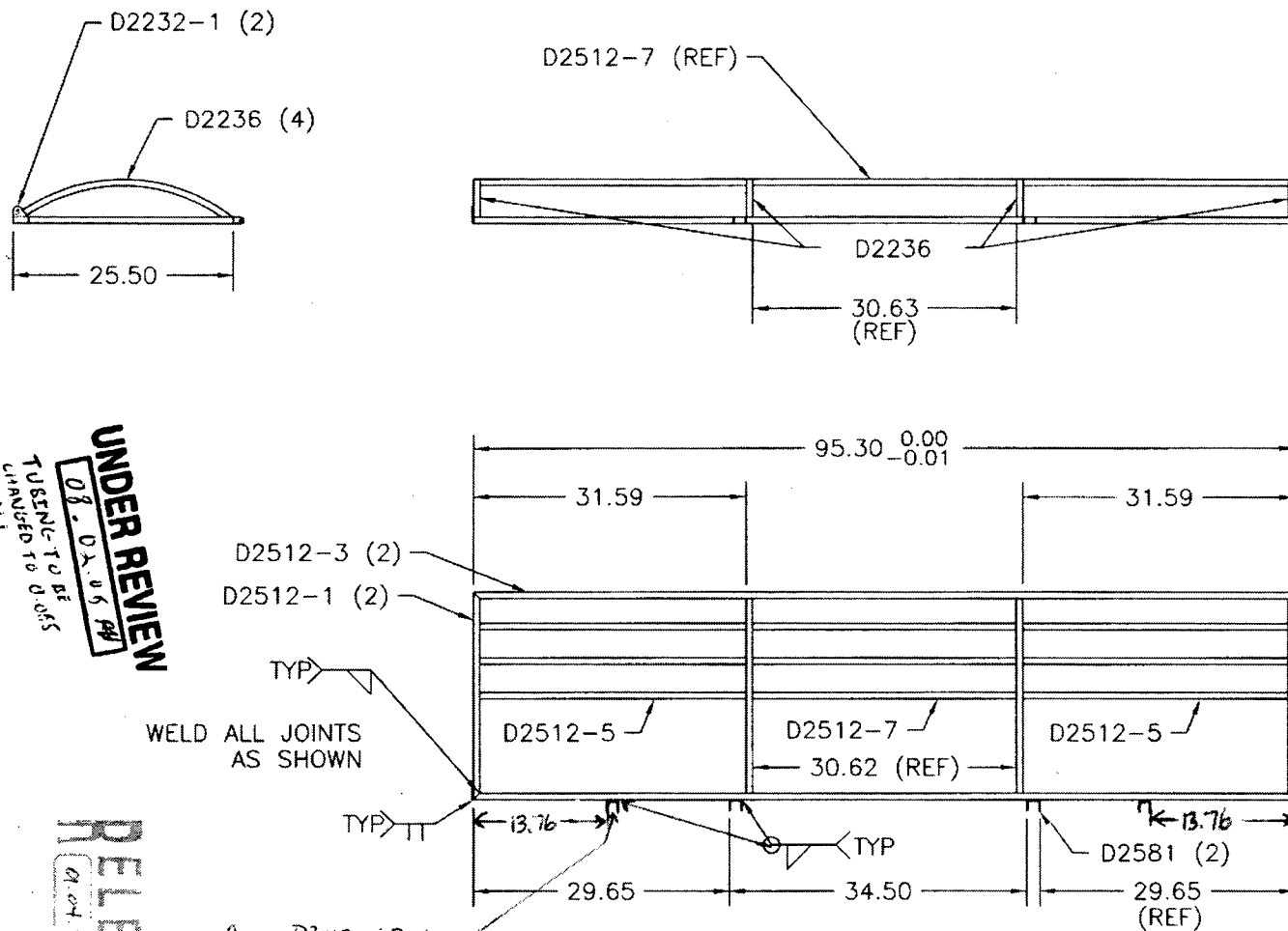
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
01.04.23

Copyright © 1995 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	UP	HANKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
#	#	D2512	SHEET 3 OF 4
DATE	TITLE	SCALE	
01.04.19	BASKET LID ASSEMBLY (350/212)	1:20	



WELD ALL JOINTS
AS SHOWN



D2012-117 CLEVIS
ADD FOR D130-701-041
ONLY (2 PLACES)

DETAIL B

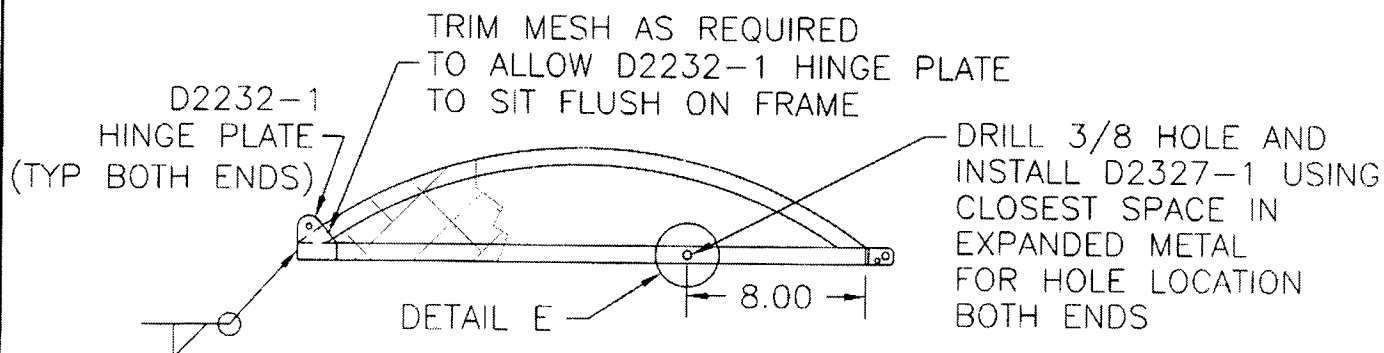
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNDER REVIEW
08.02.05
TUBING TO BE
CHANGED TO 0.065
WALL

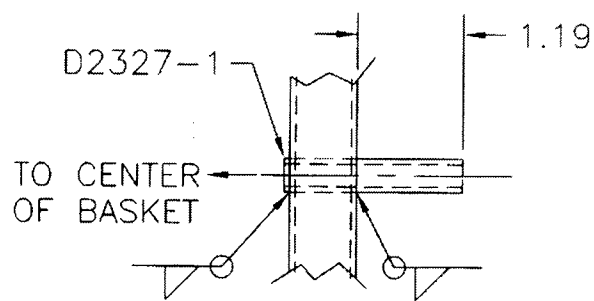
RELEASED
01.04.27



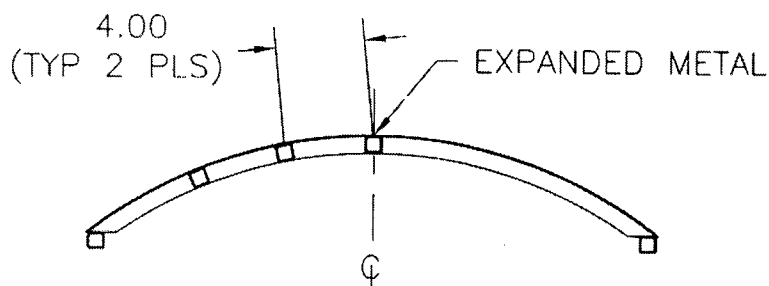
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

UNDER REVIEW
08.02.06 *PH*
TUBING TO BE
CHANGED TO 0.065
WALL

RELEASED
01.04.27 *#*

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.